

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028105**Date Inspected:** 04-Aug-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See below.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Quality Assurance Inspector (QA) Fritz Belford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

OBG

This QA observed the following welders working in OBG 12W at various locations:

Authorized welder Jin Pei Wang #7299:

Welder #7299 was observed continuing on weld 12W W2.1-A1 (4G, CJP) from the previous day with welding on the deck plating underside at Y location 3800, utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D1.5-3110-4. Welder Jin Pei Wang was also observed removing the backing bar of the weld at Y location 0 to 3000.

Authorized welder Chris Bruce #8901:

Welder #8901 was observed welding on weld 12W W2.1 PP116-BW1 (3G, CJP) panel point web complete joint penetration (CJP) weld utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1030.

Authorized welder Chang Giu Chan #2312:

Welder #2312 was observed welding on weld 12W W2.1 PP117-BW1 (3G, CJP) panel point web complete joint

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penetration (CJP) weld utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1030.

Authorized welder Jin Quan Huang #9340:

Welder #9340 was observed welding on weld 12W 13W-B1 (3G, CJP) back gouge progressing upward utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D1.5-1110A Rev.1.

This QA randomly observed OBG 12W QC Chris Conche, checking fit up of various welds, Magnetic Particle Inspecting (MT) back gouges and indications in weld back gouges, and WPS compliance of welders throughout the day.

### Magnetic Particle Testing

This QA performed Magnetic Particle Testing (MT) on the following welds:

Weld 12W W2.1 PP116-BW1:

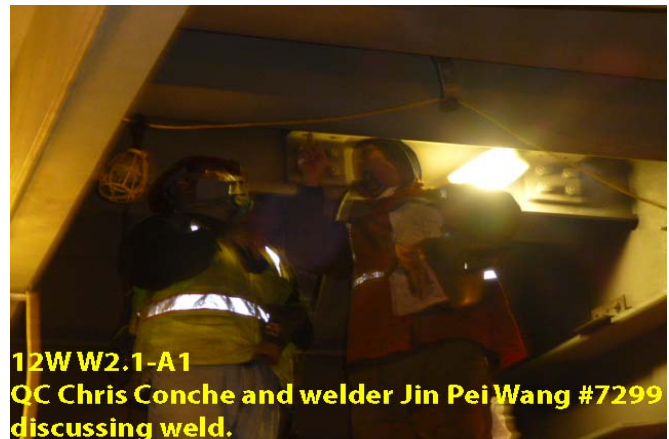
- 100% MT of Weld Back Gouge (630mm, MT Accept.)

Weld 12W W2.1 PP117-BW1:

- 100% MT of Weld Back Gouge (650mm, MT Accept.)

The above welds were previously accepted by QC Magnetic Particle technicians. This QA observed no rejectable indications at the time of testing. This QA Inspector generated a TL-6028 MT report on this date. The completed work observed at this location appeared to be in compliance with the contract specifications.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

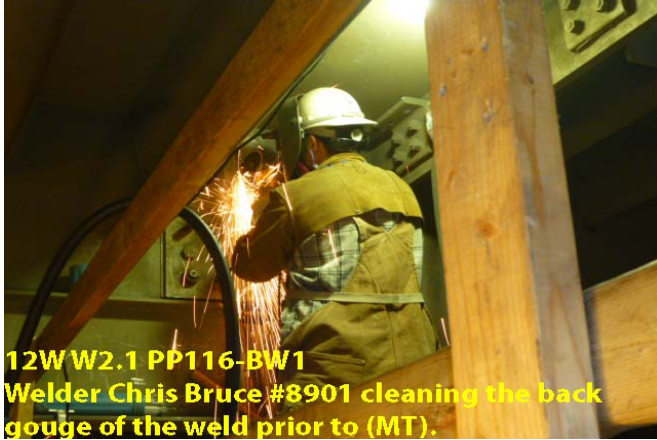


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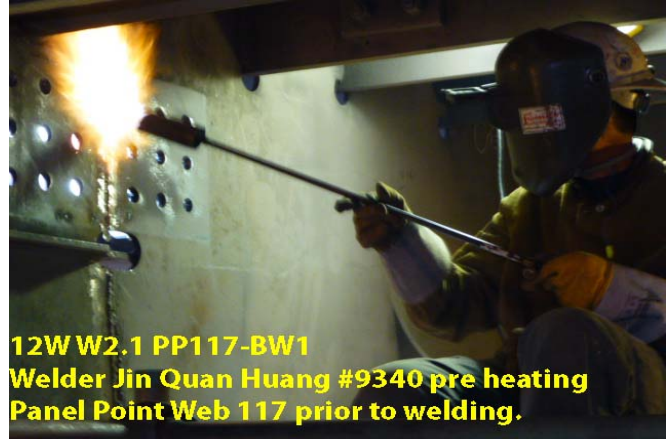
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**12W W2.1 PP116-BW1**  
**Welder Chris Bruce #8901 cleaning the back**  
**gouge of the weld prior to (MT).**



**12W W2.1 PP117-BW1**  
**Welder Jin Quan Huang #9340 pre heating**  
**Panel Point Web 117 prior to welding.**

### Summary of Conversations:

Conversations relevant to work performed on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy - (510) 385-5910, who represents the Office of Structural Materials for your project.

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**Inspected By:** Belford,Fritz

Quality Assurance Inspector

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**Reviewed By:** Levell,Bill

QA Reviewer